

ABSTRACT

METHOD FOR THE ECONOMICAL PRODUCTION OF HEAT EXCHANGER TUBES BENT IN A U-SHAPE

The invention relates to a method for the manufacture of tubes bent in a U-shape (hairpin tubes) from a nonferrous metal, immediately following a tube production line.

For that purpose, according to the invention a method for the manufacture of tubes bent in a U-shape from a nonferrous metal, immediately following a tube production line, has the consecutive steps of:

- a) uncoiling the drawn tube material from a basket winder,
- b) straightening the drawn tube material,
- c) annealing and subsequently cooling the drawn tube material before or after cutting, for separation into tube portions, to the starting length for a tube bent in a U-shape,
- d) bending the tube portions into a U-shape.

The invention also relates to a production line for the manufacture of tubes bent in a U-shape.

Figure 1